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D4353-041
Job Sheet 187752



Part No: D4353-041

Job Qty: 1 ea

Part Name: Bearpaw Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/16/18

Job Tracking No:

Due Date: 12/21/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 11-04-12 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Flow - 1	1 pcs		12/21/18	0.00	0.51	Waterjet - Flow		Dec 18/12/18
130	CNC Vertical Machining	1 pcs		12/21/18	0.98	2.70	HAAS1-4		Dec 18-12-20
140	QC	1 pcs		12/21/18	0.00	0.00	QC2 Machining-2		Dec 18-12-20
150	QC	1 pcs		12/21/18	0.00	0.00	QC8 Machining-2		Dec 18/12/20
152	Packaging	1 pcs		12/21/18	0.00	0.00	Packaging1-5	ST452 988.	DEC 21 2018
153	Small Fab	1 pcs		12/21/18	0.00	0.09	Small Fab-6		30 DAS
154	QC	1 pcs		12/21/18	0.00	0.00	QC5		DEC 21 2018 68
155	Packaging	1 pcs		12/21/18	0.00	0.00	Packaging3-2	ST452 988	DEC 21 2018 88
190	QC21-SA	1 Ea		12/21/18	0.00	0.00	QC21		DEC 31 2018 70

Part Op 120 - Cut Blank as per D4353-1 File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining. 2-Program batch number. Ensure that batch number reflects the W/O. 3-Machine as per Folio FB050 and Dwg. 4-Deburr

153 - PRESS D4353-3 INSERT INTO BEARPAW

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	6.4000 sf (6.4 ea)	120-Waterjet - Flow - 1	5045598
D4353-3	Bearpaw Insert	1 Ea (1 ea)	153-Small Fab	5060917

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Flow - 1	MUHMWB10	6	87	0
153-Small Fab	D4353-3	1	12	0

Part Specifications
Specifications could not be found.

①

Plex 12/16/18 10:00 AM dart.lacelle.linda

DART
AEROSPACE

Container No: S137769

Part: D4353-041
Job No: 187752
Serial No/Batch: S137769

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 12/16/18

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187752
~~187437~~

DART AEROSPACE LTD		Work Order:	187437
Description: Bearpaw		Part Number:	D4353-1
Inspection Dwg: D4353	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	+/-0.030	0.378	✓		Vern	GA-13
7.375	+/-0.010	7.377	✓		"	"
12.50	+/-0.030	12.50	✓		Tape	ref.
1.38	+/-0.030	1.378	✓		Vern	GA-13
3.813	+/-0.010	3.810	✓		"	"
24.00	+/-0.030	24.00	✓		Tape	ref.
10.09	+/-0.030	10.09	✓		Vern	CNC-02
1.00	+/-0.030	0.995	✓		Vern	GA-13
6.150	+/-0.010	6.150	✓		"	"
3.038	+/-0.010	3.038	✓		"	"
6.563	+/-0.010	6.562	✓		"	"
9.250	+/-0.010	9.248	✓		Vern	CNC-02
27.00	+/-0.030	27.00	✓		Tape	ref.
1.25	+/-0.030	1.250	✓		Vern	GA-13
0.30 x 45°	+/-0.030	0.295 x 45°	✓		"	"
1.38	+/-0.030	1.374	✓		"	"
0.63	+/-0.030	0.638	✓		"	"
0.95	+/-0.030	0.962	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref
0.70	+/-0.030	0.070 x 45°	✓		D-6	GA-08
0.07 x 45°	+/-0.030	0.068 x 45°	✓		Vern	GA-13
Ø0.650	+/-0.010	Ø0.651	✓		"	"
Ø0.261	+0.006/-0.001	Ø0.260	✓		"	"
0.400	+/-0.010	0.398	✓		"	"
4.750	+0.012/-0.000	4.751	✓		Vern	GA-13
4.000	+0.012/-0.000	4.001	✓		"	"
5.75	+/-0.030	5.748	✓		"	"
0.63	+/-0.030	0.638	✓		"	"
0.57	+/-0.030	0.588	✓		"	"
0.25	+/-0.030	0.266	✓		"	"
0.45	+/-0.030	0.448	✓		D-3	GA-08
0.06 x 45°	+/-0.030	0.063 x 45°	✓		Vern	GA-13
R0.25	+/-0.030	R0.250	✓		Rad-6	ref.

Measured by: G.A.	Audited by: mh	Preliminary Approval:
Date: 18-12-20	Date: 18/12/20	Date:

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	

P/O D4353-041

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